

Work Order ID 94865

94865

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Thursday, December 20, 2012 1:52:50 PM

Item ID: D4704-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Expandable Pin Assembly

Stop ***NS2***

Start Date: 12/20/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 12/20/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals:

Process Plan:

MR

Date:

12-20-20

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4704

A

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

0

FF 12-12-20

120

0.00

120

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

2

0

FF 12-12-21

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

DAJ 15 12-20-21

2

94865

Thursday, December 20, 2012 1:52:50 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Expandable Pin Assembly

Start Date: 12/20/2012 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 12/20/2012 **Req'd Qty:** 2.00 ***3***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool

**Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

SAHP

0.00

Packaging

94 334

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

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13/1/11 *AD*

12-12-21

Picklist Print

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Work Order ID: 94865

Parent Item: D4704-041

Parent Item Name: Expandable Pin Assembly

Start Date: 12/20/2012

Required Date: 12/20/2012

Start Qty: 2.00

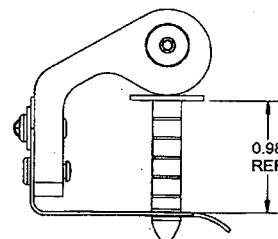
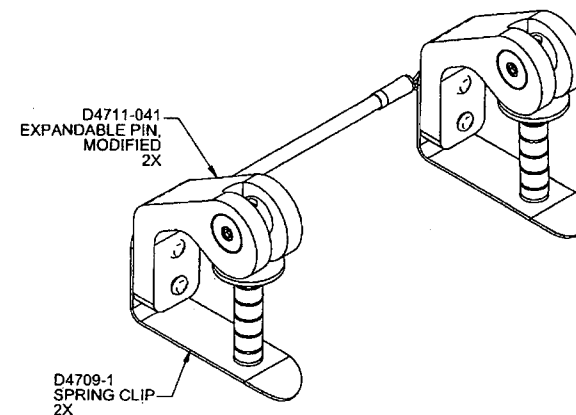
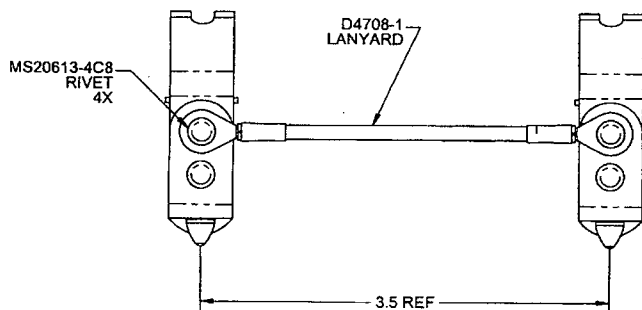
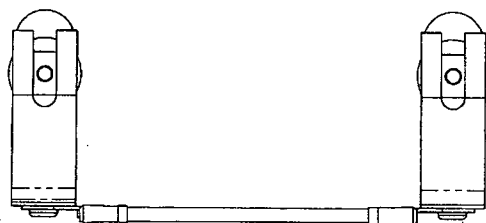
Required Qty: 2.00

Comments: IPP REV:A 12.09.10 NEW ISSUE DD VERF:JFS
DWG REV:A DD VERF:JFS

IPP REV:B 12.10.16 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4708-1 Lanyard		Manufactured	No			110	Each	26.0000	1	2		FF 12-12-20	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST118		26				2			
				89902		26							
D4709-1 Spring Clip		Manufactured	No			110	Each	21.0000	2	4		FF 12-12-21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST118	94849	21				4			
				89903		21							
D4711-041 Expandable Pin Assembly, Modified		Manufactured	No			110	Each	4.0000	2	4		FF 12-12-21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA	94866	4				4			
				92184		2				2			
				93991		2				2			
MS20613-4C8 Rivet		Purchased	No			110	Each	426.0000	4	8		FF 12-12-21	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST312		426				8			
				120242		426							

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4704-041	EXPANDABLE PIN ASSY
1	2	D4711-041	EXPANDABLE PIN, MODIFIED
2	1	D4708-1	LANYARD
3	2	D4709-1	SPRING CLIP
4	4	MS20613-4C8	RIVET



D4704-041 EXPANDABLE PIN ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4704-041" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.39 lbs

A		NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION		BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC.		
DRAWN	RP	KENT, WA		
CHECKED	A.P.	DRAWING NO.	REV. A	
MFG. APPR.	[Signature]	D4704	SHEET 1 OF 1	
APPROVED	[Signature]	TITLE	SCALE	
DE APPR.	[Signature]	EXPANDABLE PIN ASSY	NTS	
DATE	12.09.19		<small>COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

#94865
2012-10-12